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1270 Aberdeen St
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Tel (613) 632-5200
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D4435-041
Job Sheet 200171



Part No: D4435-041

Job Qty: 10 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/9/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/7/19

Type: Stock

Description:

Note: D4435 REV.C IPP REV:B 12.03.06 AS PER DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		10/7/19	0.02	0.69	Waterjet - Flow		DC 19/09/27
110	QC 2	10 pcs		10/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DC 19/09/27
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	10 pcs	10/7/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Handfinish - 1-1 Chemical- B4B	10 pcs	10/7/19	0.00 0.35	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	

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						Handfinish - 1 - 17 - B4B						
						Handfinish - 1 - 18 - B4B						
						Handfinish - 1 - 19 - B4B						
						Handfinish - 1 - 20 - B4B						
						Handfinish - 1 - 21 - B4B						
						Handfinish - 1 - 22 - B4B						
135	QC 7	10 pcs	10/7/19	0.00	0.00	QC 7 - 10						
						QC 7 - 13						
						QC 7 - 14						
						QC 7 - 15						
						QC 7 - 17						
						QC 7 - 18						
						QC 7 - 19						
						QC 7 - 2						
						QC 7 - 28						
						QC 7 - 3						
						QC 7 - 30						
						QC 7 - 34	BL19-10-01					
						QC 7 - 36						
						QC 7 - 37						
						QC 7 - 41						
						QC 7 - 47						
						QC 7 - 48						
						QC 7 - 51						
						QC 7 - 58						
						QC 7 - 59						
						QC 7 - 60						
						QC 7 - 9						
						QC 7 - 68						
						QC 7 - 50						
						QC 7 - 67						
						QC 7 - 40						
						QC 7 - 24						
						QC 7 - 43						
						QC 7 - 61						
						QC 7 - 81						
140	Powdercoat - 4 Black Sand - B4B	10 pcs	10/7/19	0.00	0.34	Powdercoat - 1 - B4B						
						Powdercoat - 2 - B4B						
						Powdercoat - 3 - B4B						
						Powdercoat - 4 - B4B						
						START: 1135 A.T. 30° FINISH: 1105.						
150						QC 3	10 pcs	10/7/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13						
						QC 3 - 15						
						QC 3 - 17						
						QC 3 - 18						
						QC 3 - 2						
						QC 3 - 28						
						QC 3 - 3						
						QC 3 - 30						
						QC 3 - 34						
						QC 3 - 36						
						QC 3 - 41						
						QC 3 - 51						
						QC 3 - 58						
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					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
160	Small Fab - 2 - B4B	10 pcs	10/7/19	0.00 1.34	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
170	QC 5	10 pcs	10/7/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190	Packaging 3-1 - Stock - B4B	10 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

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					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
200 QC 21 - SA	10 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	DAS	
				QC 21 - SA - 70	21	OCT 04 2019
				QC 21 - SA - 53	9-59	

Part Op 100 - 1-Cut D4435-1 as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr if necessary
 Descriptions: 110 - QC2 Waterjet-3 (QC2- Inspect parts off machine FAI/FAIB)
 120 - QC8-4 (QC8- Inspect parts - second check)
 130 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)
 135 - QC7-3 (QC7-Inspect Chemical Conversion Coat)
 140 - Powdercoat4 (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 150 - QC3 (QC3- Inspect Part Finish)
 160 - Small Fab-6 (Small Fab) 1- Cut rubber seal at 3.50" 2-Glue rubber seal to bracket as per dwg (SHEET 1, NOTE 8)
 170 - QC5 (QC5- Inspect part completeness to step on W/O)
 190 - Packaging3-2 (Identify as per dwg & Stock Location: _____)
 200 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	.4300 sf (.043 ea)	100-Waterjet - Flow - 1	
D4441-1	Rubber Seal	2.9160 ft (.2916 ea)	160-Small Fab - 2 - B4B	S2041169 S092162

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	0	518	0
160-Small Fab - 2 - B4B	D4441-1	3	280	0

Part Specifications	
Specifications could not be found.	

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Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ Machining ☐ ☐ Large Fab ☐ ☐ Cross tube ☐ ☐ Small Fab ☐ ☐ Finishing ☐ ☐ Eng. (Non-AW) ☐ ☐ Prod. Eng. Coord. ☐ ☐ Rec/Store/Packaging ☐ ☐ Engineering ☐ ☐ Water Jet ☐ ☐ Supplier ☐ ☐ Quality ☐ ☐				MRB (QS1042)																													
Date:		Sequence #:		QTY Affected:		Disposition																																	
Description Work Order Deviation						Completed By																																	
						Lead hand / Supervisor																																	
						QC / QA Coordinator																																	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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